

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009786**Date Inspected:** 22-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**1AE & 1BE**

This QA Inspector performed Ultra Sonic (UT) inspection (partial) of weld joint OBW1A-003 (bottom plate), OBW1A-005(side plate) and OBW1A-004 (side plate) on cross beam side of segment 1W, utilizing scanning pattern D to detect transverse indication reflectors. Noted UT inspection was performed in conjunction with ABF UT Department. This QA Inspector did not complete the full length of the above noted weld due to weld repair area performed weld repair work in progress and rough surface condition. Y Locations are as followed for description of rework per weld joint.

OBW1A-003: Y location 90~775 (rough surface), 5560~6040 and 6950~7460 (weld repaired area).

OBW1A-004: Y location 980~2770 (weld repair in progress).

See Caltrans's Ultrasonic Transverse Indication Evaluation report sheet dated 10-22-09 for future information on inspection performed on this work day.

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## WELDING INSPECTION REPORT

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This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG 1AAW+1AW side plate (c. b side of segment) weldment previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1. 5-2002, section 6, table 6.3. The QA Inspector observed 1 rejectable longitudinal linear indication at the time of testing. The QA Inspector generated a TL-6027 UT report on this date. Welds UT verified was identified as listed below:

### 1. OBE1A-004

This QA Inspector observed one (1) Class A discontinuities present in the weldment accepted by ZPMC QC UT personal. This QA Inspector issued an incident report on the above noted UT rejections.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Alaniz,Joe     | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Carreon,Albert | QA Reviewer                 |

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